

split 1/1  
Work Order ID 126537-3  
Thursday, November 13, 2014 8:35:09 AM

\*126537\*

Ship Nov. 21

Page 1

Item ID: D3779-041

Revision ID:

Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14

Start Qty: 26.00

Required Date: 11/20/14

Req'd Qty: 26.00

Reference:

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 14-11-12 Tooling:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3779

C

100

\*100\*

Waterjet

FLOW WATER JET

0.00

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3779-1  
Dwg Rev: C  
Prog Rev: C  
2-Deburr if necessary

6061.125

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

DAS  
23  
9-89

14-11-13

DAS  
23  
9-89

14-11-13

DAS  
38  
9-89

(28)

NOV 13 2014





**Work Order ID 126537**

Thursday, November 13, 2014 8:35:09 AM

**\*126537\***

Page 2

Item ID: D3779-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Handle Assembly (Exterior)

Stop **\*NS2\***

Start Date: 11/17/14 Start Qty: 26.00

**\*26\***

Required Date: 11/20/14 Req'd Qty: 26.00

**\*26\***

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

0.00

Memo

0.00

1- Counter sink holes as per dwg D3779  
2- Deburr

28

DAS  
36  
9-89  
11/14/17

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

28

DAS  
38  
9-89

NOV 17 2014

150

**\*150\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

28 11-11-19

38



# Work Order ID 126537

Thursday, November 13, 2014 8:35:09 AM

**\*126537\***

Page 3

Item ID: D3779-041

Revision ID:

Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14 Start Qty: 26.00

Required Date: 11/20/14 Req'd Qty: 26.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

DAS  
30  
9-89

10

14/12/17

180

Small Fab

0.00

**\*180\***

Small Fab

Memo

0.00

Small Fab

1- Rivet handle to D3779-1 plate as per dwg D3779 per QSI003

10

FF

DEC 17 2014

PTO

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

Memo

0.00

Quality Control

DAS  
38  
9-89

10x

✓

DEC 17 2014



DEC 3 1944

DEC 3 1944

**Work Order ID 126537**

Thursday, November 13, 2014 8:35:09 AM

**\*126537\***

Page 4

Item ID: D3779-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Handle Assembly (Exterior)

Stop **\*NS2\***

Start Date: 11/17/14 Start Qty: 26.00

**\*26\***

Required Date: 11/20/14 Req'd Qty: 26.00

**\*26\***

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Identify as per dwg & Stock Location: SS15

0.00

**\*200\***

Packaging

Memo

0.00

10DAS  
86  
8-09

DEC 17 2014

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

14/12/18  
12-17





DQA:

Date: 15/05/05



QA Closed:

Date: 15/05/04

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>126537</u>	<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D 3779-7</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. <u>15-4871</u>	Scrap <input checked="" type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	DEC 17 2014	180	1	Found one handle damaged scrap and Replace	S	Replace D 3779-7	FF	DAS 38 9-89	
Doc/Data							DEC 17 2014	14-17-12	
Equip/Tooling									
Handling/Pre	X								
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

DEC 11 1964

DEC 11 1964



# Picklist Print

Thursday, November 13, 2014 8:35:14 AM

Page 1

Work Order ID: 126537

Parent Item: D3779-041

Parent Item Name: Handle Assembly (Exterior)

\*126537\*

\*D3779-041\*

Start Date: 11/17/14

Required Date: 11/20/14

Start Qty: 26.00

Required Qty: 26.00

Comments: IPP Rev:A 08-06-09 new issue DD verified by:ec  
IPP Rev:B 08-07-21 procedure change DD verified by:EC IPP Rev:C  
11.12.02 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	149.3910	0.194	6			DAS 23 9-89

\*M6061T6S 125\*

\*\*

14-11-1

## Location

## Loc Qty

## Loc Code

MAT021

149.391

m127272

29.2

m127454

24.703

m127501

5.1

m128852

6.938

m130524

21.45

m130745

62

Manufactured No

180

Each

0.0000

1

26

\*\*

10 FF

DEC 17 2014

D3779-7

\*D3779-7\*

Handle

MS20426AD10-9A

Purchased No

\*MS20426AD10-9A\*

RIVET

180

Each

118.0000

4

104

\*\*

FF

DEC 17 2014

## Location

## Loc Qty

## Loc Code

ST311

118

125170

1

M127659

17

M130862

100

40



REVISED

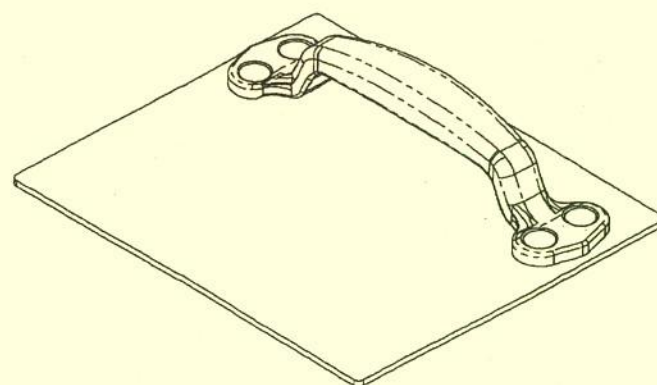
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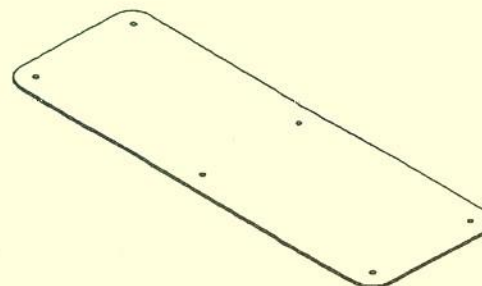




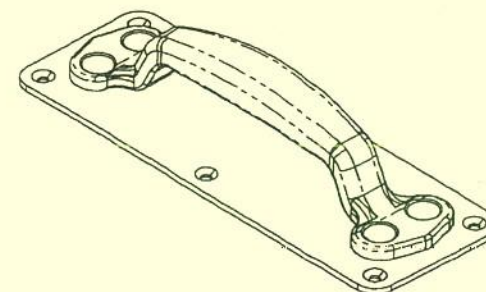
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
	1	D3203-1	HANDLE
1		D3779-1	PLATE
1		D3779-5	PLATE
1		D3779-7	HANDLE
4	4	MS20426AD10-9A	RIVET, CSK



**D3779-043 HANDLE ASSEMBLY  
(INTERIOR)**



**D3779-3 DOUBLER PLATE**



**D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: (SEE SHEETS 2 & 3)
- 7) WEIGHT: D3779-3: 0.14 lbs  
D3779-041: 0.71 lbs  
D3779-043: 1.14 lbs

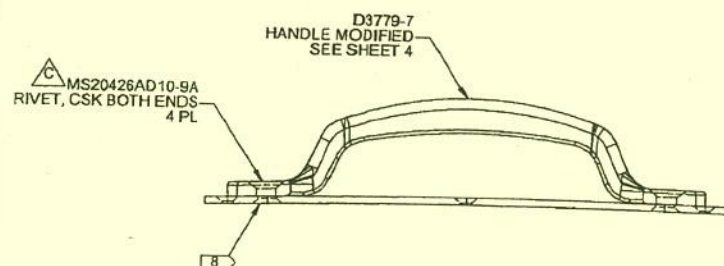
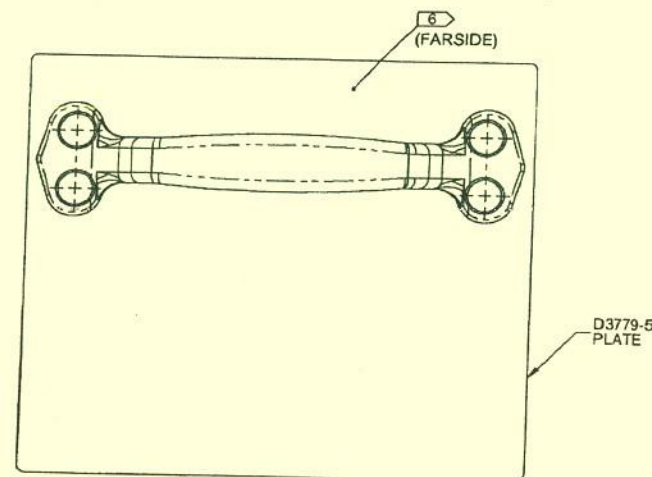
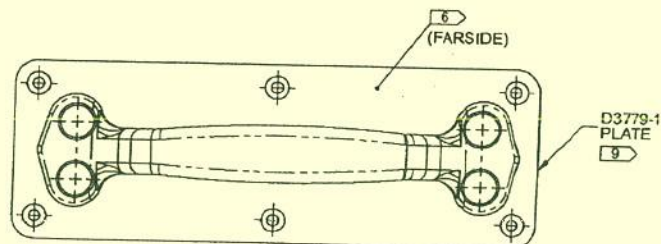
*Handwritten:* 126537

**RELEASED**  
2012-07-23  
*Handwritten initials:* MP

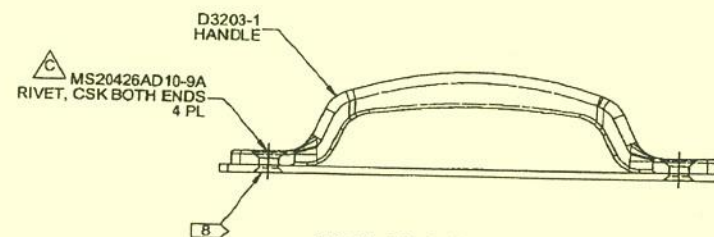
C	CHANGED RIVET FROM -8 TO -9A CHANGED D3779-041 FROM FLAT TO CONTOURED	RP	12.04.26
B	REFORMAT IAW DART QSI 043, MS20426AD10-9 WAS MS20426AD10-8 (2N D6-1, B/SB4-2). REASON: PRODUCTION FACILITY (PAR11-136)	MB	11.11.24
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	<i>Handwritten initials</i>	D3779	SHEET 1 OF 4
APPROVED	<i>Handwritten initials</i>	TITLE	SCALE
DE APPR.	<i>Handwritten initials</i>	HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	12.04.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE COMPANY IDENTIFIED ONLY IF NO NOT TO BE RELEASED FOR ANY PURPOSES OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







**D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY  
(INTERIOR)**

**NOTES:**

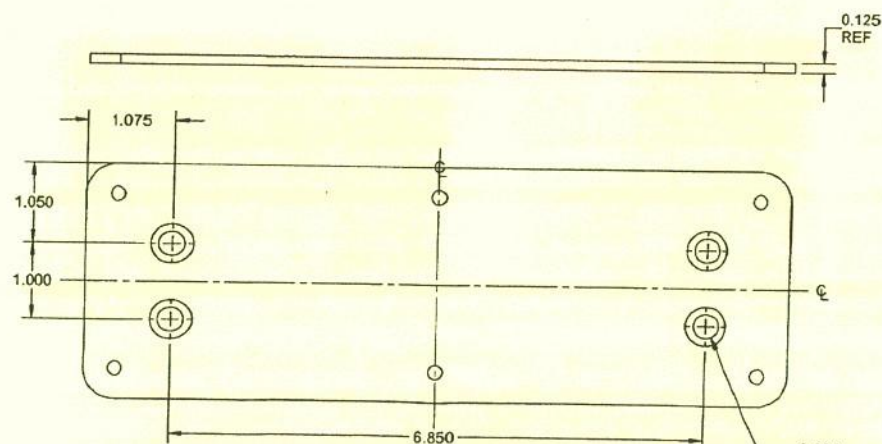
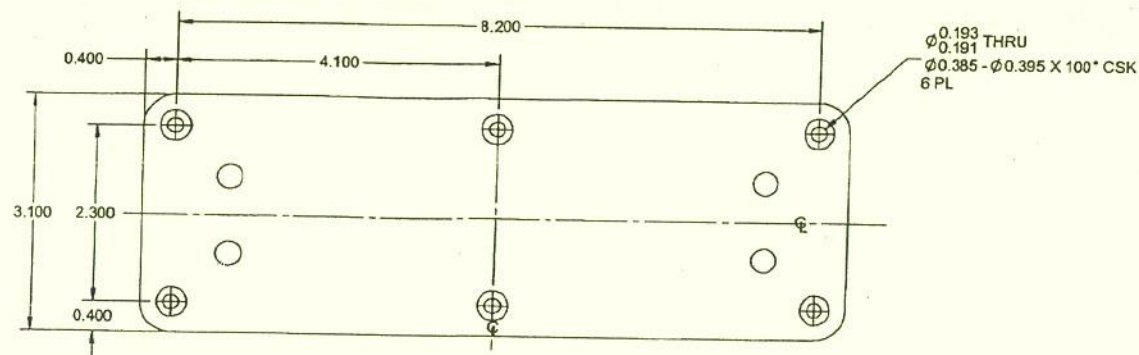
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-XXX" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: D3779-041: 0.71 lbs  
D3779-043: 1.14 lbs
- 8) RIVETS TO BE PEENED AND GROUND FLUSH.
- 9) FORMED TO FIT D3779-7 HANDLE DURING ASSEMBLY.

**RELEASED**  
2012-07-23

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RP			
CHECKED	A.P.		DRAWING NO.	REV. C
MFG. APPR.	E.P.		D3779	SHEET 2 OF 4
APPROVED	AY		TITLE	HANDLE ASSEMBLY, SCAL
DE APPR.	W		CABIN SLIDING DOOR	NT
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**D3779-1 PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4027  
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

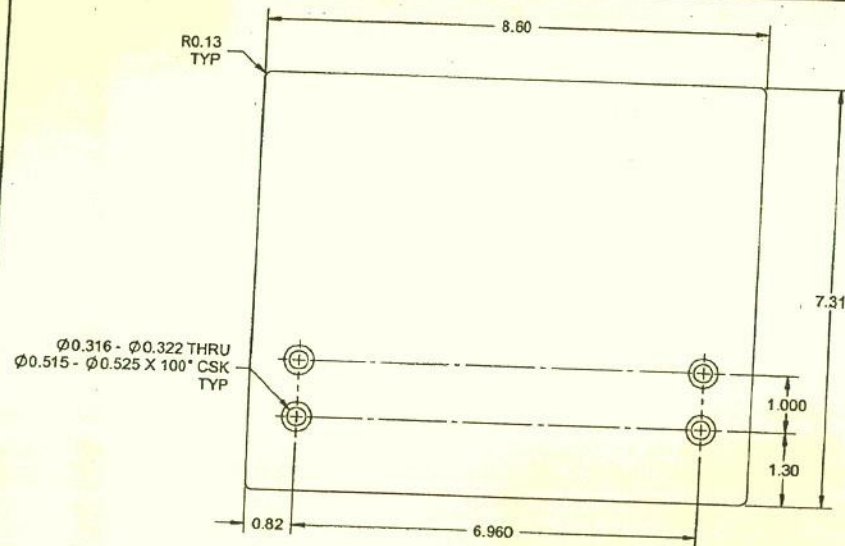
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DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3779</b>	REV. C SHEET 3 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE <b>HANDLE ASSEMBLY CABIN SLIDING DOOR</b>	
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	SCALE NTS	
DATE	12.04.26		

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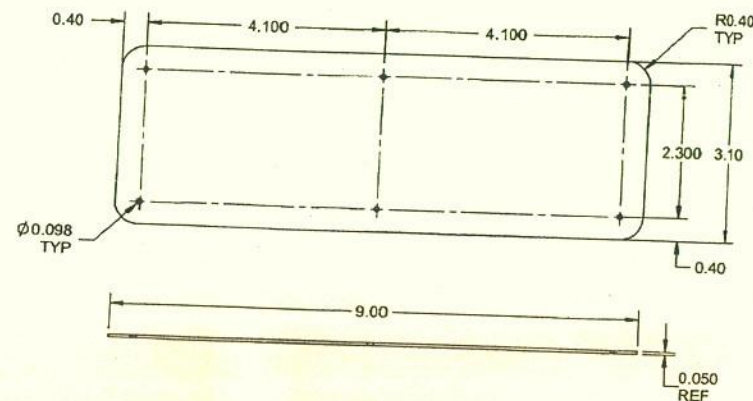
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2012-07-23  
*[Signature]*



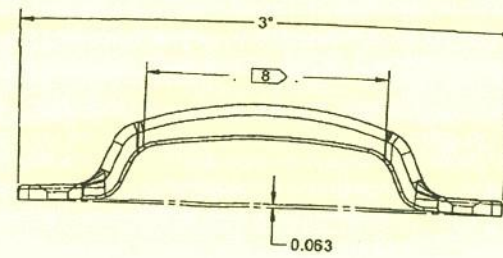




**D3779-5 PLATE**



**D3779-3 DOUBLER PLATE**



**D3779-7 HANDLE, MODIFIED**

**NOTES:**

**1) MATERIAL:**

D3779-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.050)

D3779-5: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4027  
(REF DART SPEC M6061T6S.125)

D3779-7: MADE FROM D3203-1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: D3779-3: IDENTIFY WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1

D3779-5: NONE

D3779-7: NONE

7) WEIGHT: D3779-3: 0.14 lbs

D3779-5: 0.76 lbs

D3779-7: 0.38 lbs

8) BEND HANDLE THROUGH THIS AREA ONLY

**RELEASED**  
2012-07-23

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.R.	DRAWING NO.	REV. C
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b>	
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